

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013220**Date Inspected:** 10-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Cheng/Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay#14**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(CA61-033, 034)

-(CA89-045, 046, 021, 022)

-(CA91-017, 018, 029, 030)

-(SEG51D-047, 052)

**Bay#19**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SB008-046-049, 055, 061, 067, 001, 004, 005, 007, 019)

**Bay#14**

FCAW welding of weld joint SSD16A-PP104-240, 250, 241, 251 located on Segment11DE. Welder is identified as 058551 (1G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to

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comply with the Applicable WPS-B-T-2231-Tc-U4c-F.

FCAW welding of weld joint Seg072\*-031 located on Segment11DE. Welder is identified as 048038 (1G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-223(2)1-T-2.

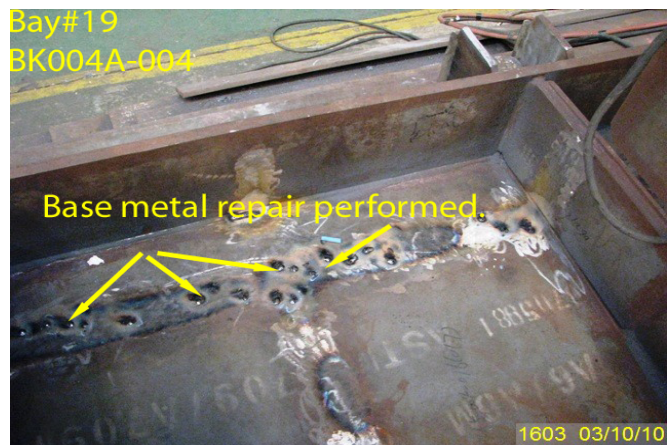
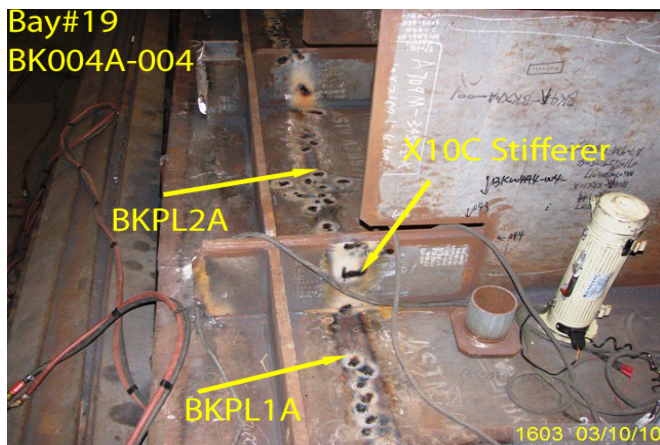
SMAW welding of weld joint Seg074A-001 located on Segment11EE. Welder is identified as 200113 and 049339 (4G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint Seg072\*-045 located on Segment11DE. Welder is identified as 044772 (4G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

### Bay#19

During random in process inspection of Bike Path, BK4A-004, this QA inspector observed that ZPMC performed base metal repair on BKPL1A and BKPL2A. This base metal repair performed with SMAW welding process, after removing the outer cover plate by carbon arc gouging. For further information, please see the attached pictures below.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Patel,Hiranch

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer